

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69919

Tuesday, May 24, 2011 2:18:54 PM



Page 2

Item ID:	D2939-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle RH In, 206					
Start Date:	5/24/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	5/31/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/07/12		6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6		BL 11-7-12	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

7:45

6X ✓ m-l 11/07/12

M 11/7/12

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NOTE: Date & initial all entries

Work Order ID 69919



Tuesday, May 24, 2011 2:18:54 PM






Page 3

Item ID: D2939-2 Accept  Setup Start 
Revision ID:
Item Name: Saddle RH In, 206 Stop 
Start Date: 5/24/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	0	11/07/12	
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>429</u> Memo	0.00 0.00						11/7/13 (6)	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/7/13	

ME
11-07-13

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 24, 2011 2:19:00 PM

Page 1

Work Order ID: 69919



Parent Item: D2939-2



Parent Item Name: Saddle RH In, 206

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	51.0000	1	6			
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Saddle Billet



29 11.7.8

Location

Loc Qty

Loc Code

MAT040

51

64777

20

66965

10

68170

21

7079/

6

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD				Work Order: 69919	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.120	.121	.120	.119	.119
B	0.100	0.140		.119	.121	.120	.119	.119
C	0.100	0.140		.113	.112	.112	.111	.111
D	0.210	0.230		.220	.218	.218	.218	.219
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.240	.239	.239	.239	.240
N	0.100	0.140		.120	.119	.121	.120	.120
O	0.540	0.560		.551	.551	.550	.550	.550
P	0.490	0.510		.500	.499	.499	.499	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.249	.250	.250
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.261	1.259	1.260	1.259	1.260
Y	1.565	1.585		1.576	1.574	1.575	1.574	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: SL	Date: 11/07/11
Audited by: B.A	Date: 11/07/12
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

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Description: 206 Saddle, Inboard, Right side				Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

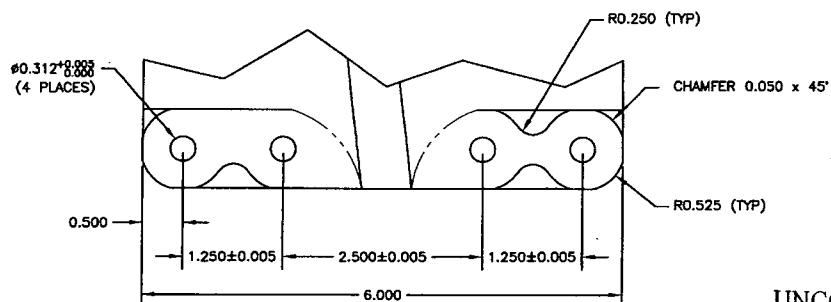
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
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C	0.100	0.140		.112				
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H	0.510	0.515		.500				
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K	0.257	0.262		.257				
L	0.312	0.317		.313				
M	0.235	0.240		.240				
N	0.100	0.140		.100				
O	0.540	0.560		.550				
P	0.490	0.510		.500				
Q	3.715	3.725		3.700				
R	2.720	2.760		2.740				
S	0.240	0.270		.249				
T	0.100	0.180		.140				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.250	1.270		1.260				
Y	1.565	1.585		1.575				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
Accept/Reject								

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Audited by:	B.A	Date:	11/07/12
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
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B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

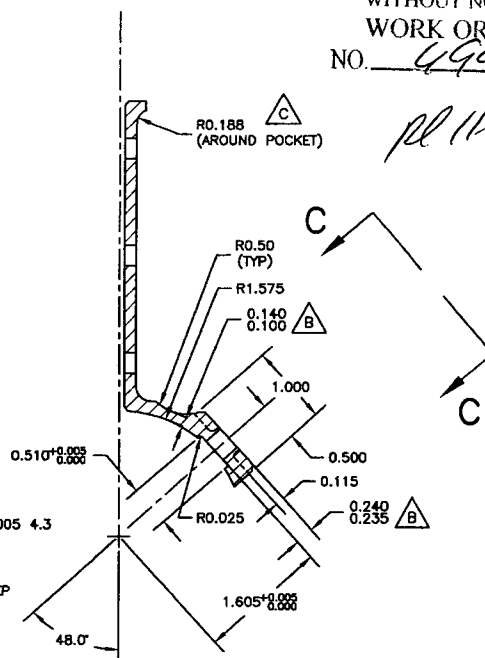


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

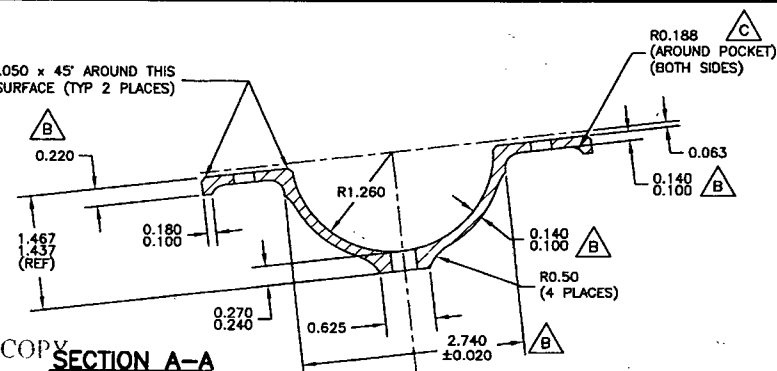
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

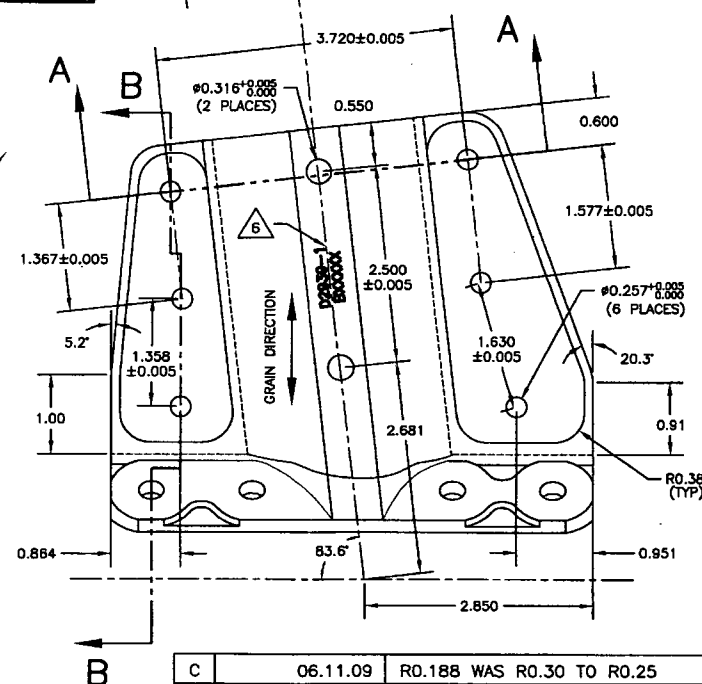


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO. D2939
 SHEET 1 OF 1
 SCALE 2:3

01.02.12

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